

Date: Wednesday, 01/04/2009 9:10:22 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : RIB ASSY (BASKET END)
<b>Job Number</b> : 46773	
<b>Estimate Number</b> : 13666	
<b>P.O. Number</b> :	
<b>This Issue</b> : 01/04/2009 <b>S.O. No.</b> :	<b>Part Number</b> : D3825041
<b>Prsht Rev.</b> : NC	<b>Drawing Number</b> : D3825 REV A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Project Number</b> : N/A
<b>Previous Run</b> : 46390	<b>Drawing Revision</b> : A
<b>Written By</b> :	<b>Material</b> :
<b>Checked &amp; Approved By</b> : <u>JUD 09.04.09</u>	<b>Due Date</b> : 07/04/2009 <b>Qty:</b> 6 <b>Um:</b> Each
<b>Comment</b> : Est Rev:A 08-12-01 new issue DD verified by:EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D23273	Spacer Bushing
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Spacer Bushing

Batch: B39560

2.0	D37591	Bushing
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bushing

B45890

3.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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**Comment:** Qty.: 2.2313 f(s)/Unit Total : 13.3875 f(s)

304 SQ Tube .75x.75x.065W

batch: B4111148

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1- cut D3825-1 rib as per dwg D3825

2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

PD 09.04.02 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 01/04/2009 9:10:22 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB ASSY (BASKET END)

Job Number: 46773

Part Number: D3825041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/04/02 (X6)

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825

A/R ER316 S.S. Rod Batch: M108160

2- grind bushing weld flush where indicated on dwg D3825

3- deburr if necessary

PD 09-04-03 (6)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

CP 09-04-03

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/04/03 (X6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Basket

PD 09-04-06 (6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/06 (X6)

Job Completion



mf  
09-04-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

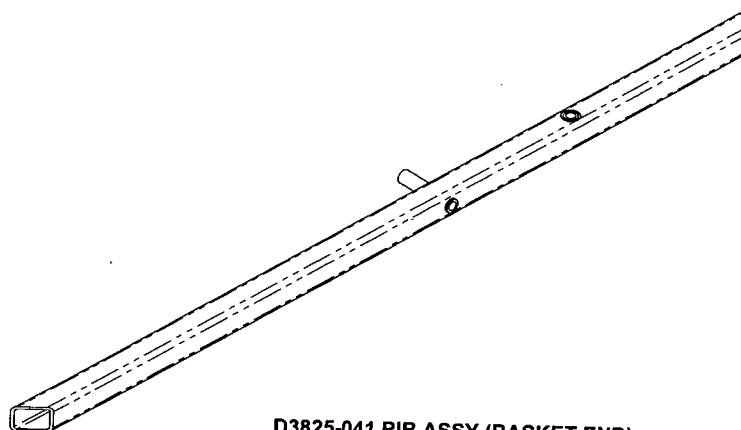
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3825-041	RIB ASSEMBLY (BASKET END)
2	1	D2327-3	SPACER BUSHING
3	1	D3759-1	BUSHING
4	1	D3825-1	RIB



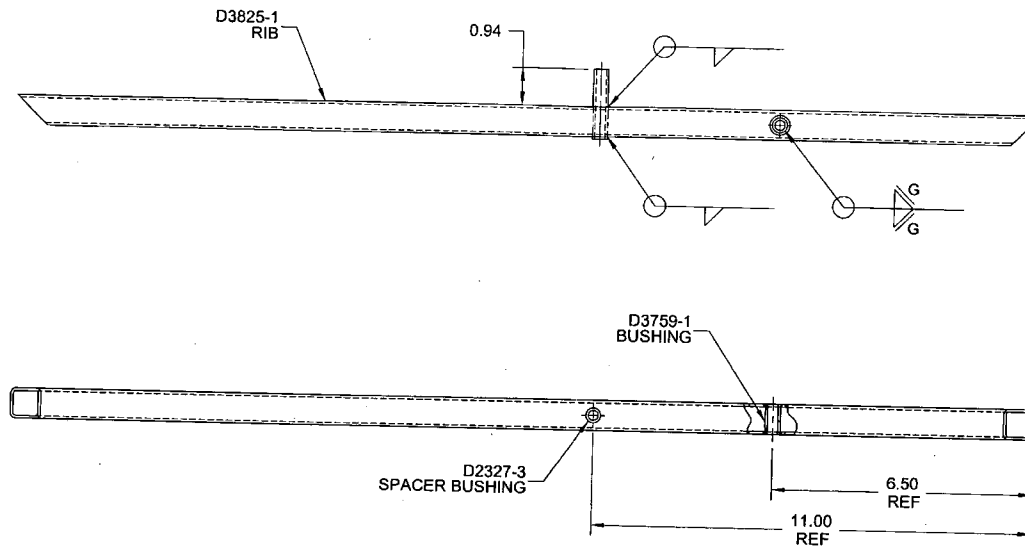
**D3825-041 RIB ASSY (BASKET END)**

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40003

**RELEASED**  
08/11/18/17

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.22 lbs
  - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	08.09.23
REV.		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. A
CHECKED		D3825	SHEET 1 OF 3
MFG. APPR.		TITLE	SCALE
APPROVED		RIB ASSY (BASKET END)	NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.09.23		

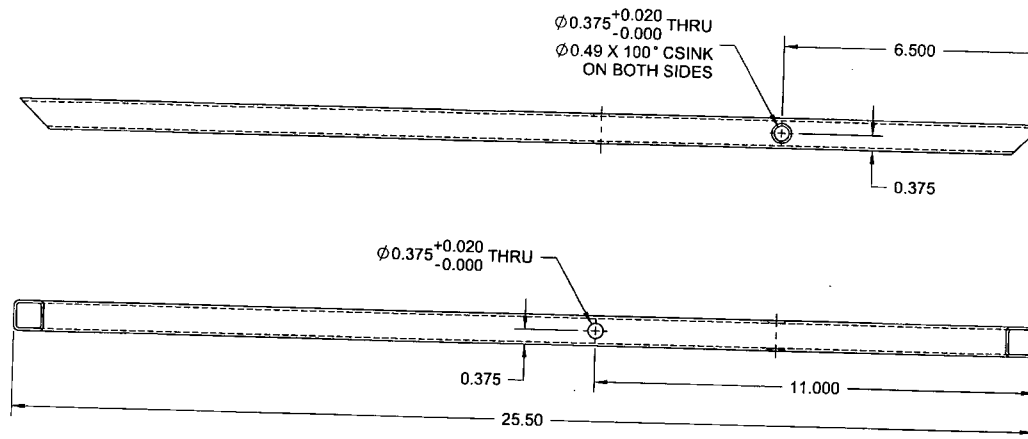
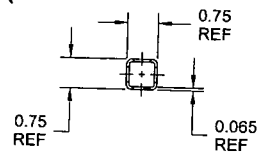


**D3825-041 RIB ASSY (BASKET END)**

**RELEASED**  
08/11/18 NW

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.		D3825	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
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WITHOUT NOTICE  
WORK ORDER  
NO 46273



**D3825-1 RIB**

NO. *100273*  
 WORK ORDER  
 WITHOUT NOTICE  
 UNCONTROLLED COPY  
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 ENGINEERING  
 RETURN TO  
 SHOP COPY

- NOTES:  
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
 REF: DART SPEC. M304TS0.750W0.065  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 1.18 lbs

**RELEASED**  
*08/11/13 MB*

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RC</i>	DRAWING NO.	REV. A
MFG. APPR.		<b>D3825</b>	SHEET 3 OF 3
APPROVED	<i>1/11/13</i>	TITLE	SCALE
DE APPR.	<i>MB</i>	<b>RIB ASSY (BASKET END)</b>	NTS
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